

Work Order ID 74586

Monday, October 03, 2011 11:31:36 AM



U/R

Page 1

Item ID: D350-748-141TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/03 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-748-141

F U/R

OK

11/10/02

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3- File transition lines smooth.

FOLIO REV: AA

DWG REV: F

1 Ø
mm. L 11/11/02

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

1 Ø
mm. L 11/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D350-748-141TRN

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Start Date: 10/3/2011 Start Qty: 1.00

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Mori Seiki Mori Seiki CNC Lathe Large	MORI SEIKI CNC LATHE LARGE Memo 1-Turn second side as per Folio FA648 2- File transition lines smooth. 3-Scribe Part & Batch as per Dwg D350-748-141 FOLIO REV: <u>AF</u> DWG REV: <u>F</u>	0.00 0.00							<u>1</u> <u>Ø</u> mm.L 11/11/03
130  QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00							<u>1</u> <u>Ø</u> mm.L 11/11/03
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							<u>11-11-3</u>

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Crosstubes

Large Fab

0.00

Memo

0.00

Grind machining marks

TW

11-11-03

160



Outsource1

Outsource process - Heat Treat

0.00

Memo

0.00

Outsource process - Heat Treat

Issue P/O: 15874
Heat Treat to min 180 KSI As per Dwg D350-748-141
(MIL-T-6736 OR AMS 2759-1C)
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

11-11-04

170



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

10/11/21/150

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 10/7/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

190

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack
Location: Back hall

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/22

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Picklist Print

Page 1

Monday, October 03, 2011 11:31:41 AM

Work Order ID: 74586



Parent Item: D350-748-141TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 10/3/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
 IPP Rev B Removed polish 08.04.02 EC verified by : DD
 IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C
 11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125 		Manufactured	No			110	Each	22.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

HALL

22

61380

22

1

amril 11/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74586
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	/		vern	CWC-08
	2.180	+0.005/-0.000	2.185	/		"	
	2.180	+0.005/-0.000	2.185	/		"	
	2.237	+0.005/-0.000	2.241	/		"	
	2.272	+0.005/-0.000	2.277	/		"	
	2.306	+0.005/-0.000	2.311	/		"	
	2.339	+0.007/-0.000	2.344	/		"	
	2.339	+0.007/-0.000	2.344	/		"	
	0.062	+/-0.010	.062	/		vern	CWC-08
	4.26	+/-0.030	4.265	/		"	
	R0.063	+/-0.010	.063	/		RG	
	R0.50	+/-0.030	.500	✓		"	
SIDE B	2.240	+0.005/-0.000	2.244	/		vern	CWC-08
	2.180	+0.005/-0.000	2.184	/		"	
	2.180	+0.005/-0.000	2.184	/		"	
	2.237	+0.005/-0.000	2.240	/		"	
	2.272	+0.005/-0.000	2.276	/		"	
	2.306	+0.005/-0.000	2.309	/		"	
	2.339	+0.007/-0.000	2.346	/		"	
	2.339	+0.007/-0.000	2.346	/		"	
	0.062	+/-0.010	.062	/		vern	CWC-08
	4.26	+/-0.030	4.265	/		"	
	R0.063	+/-0.010	.063	/		RG	
	R0.50	+/-0.030	.500	✓		"	
	110.27	+/-0.060	110.265			tape	mm.l-02

Measured by: mm.l	Audited by: DP	Preliminary Approval:
Date: 11/11/11	Date: 11-11-3	Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	

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Item	Qty	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74586

M.L.J.
11/10/03
UNDER REVIEW
OK [Signature]

RELEASED
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-048 (ZN A6-3); TOLERANCES (ZN C8-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. F
MFG. APPR.	DP	D350-748-141	SHEET 1 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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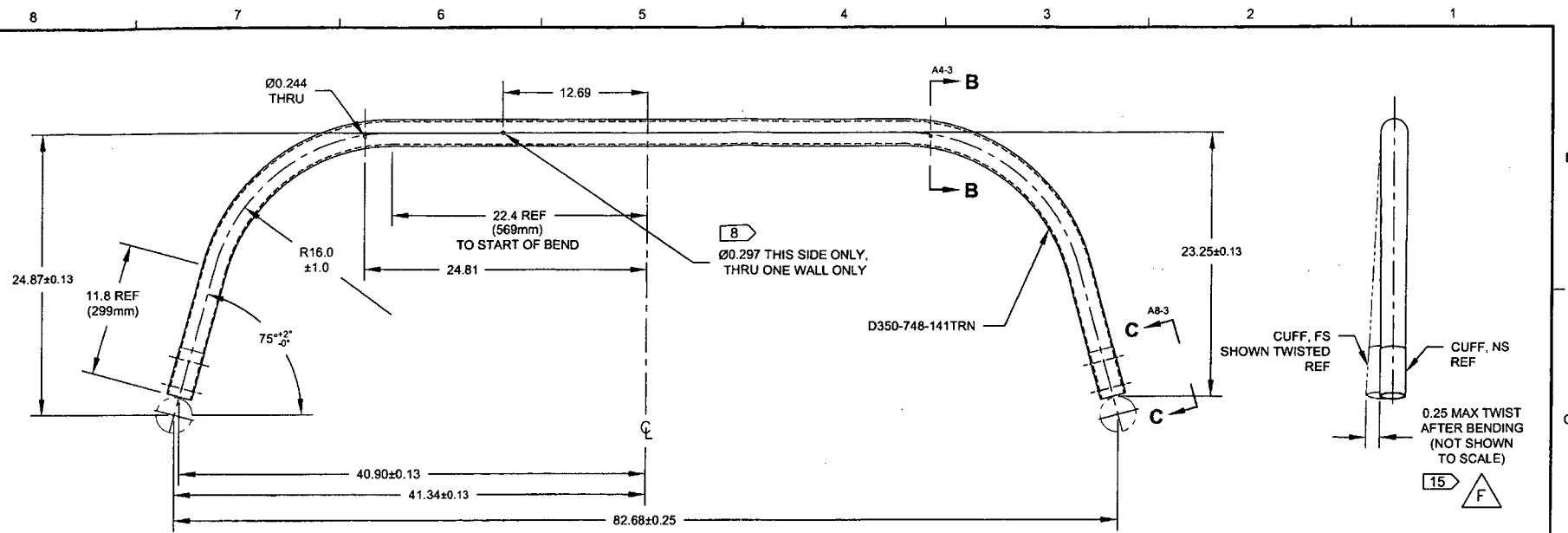
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

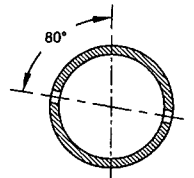
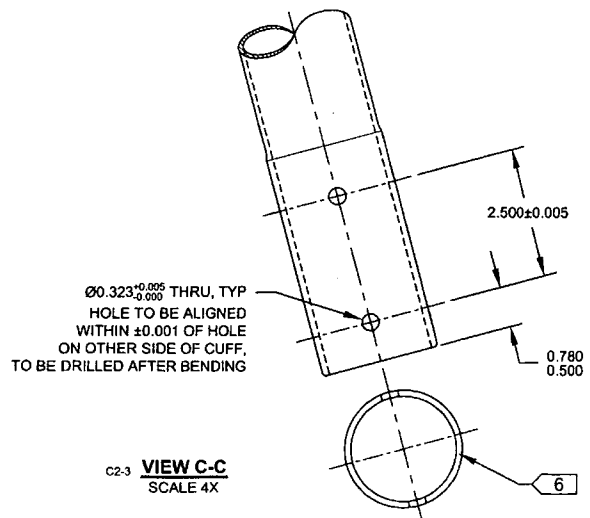
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74586



D350-748-141
BENDING AND DRILLING DETAIL 10



UNDER REVIEW
11-07-12

RELEASED
2011-01-18

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. F
MFG. APPR.	DP	D350-748-141	SHEET 3 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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8 7 6 5 4 3 2



UNDER REVIEW

11.07.12



A



RELEASED
2011-01-18

DESIGN	<i>90</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D350-748-141 TITLE CROSSTUBE (AS 350/355 HI FWD) DATE 10.11.23	REV. F
DRAWN	<i>90</i>		SHEET 4 OF 4
CHECKED	<i>15</i>		
MFG. APPR.	<i>15</i>		
APPROVED	<i>15</i>		
DE APPR.	<i>15</i>		
DATE 10.11.23		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENTARY IS PRINTED BY DART AEROSPACE LTD. IT IS HEREBY AGREED THAT NO PART OF THIS DOCUMENTARY OR INFORMATION CONTAINED THEREIN IS TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN SANCTIONED AUTHORITY OF DART AEROSPACE LTD.	

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VAC AERO

INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 136092-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

12/13/2011

MM/DD/YYYY

PAGE: 1

1DAR01

LL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
12/13/2011		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
15376		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
----------	-------------	-----	------------	-------------	--------------

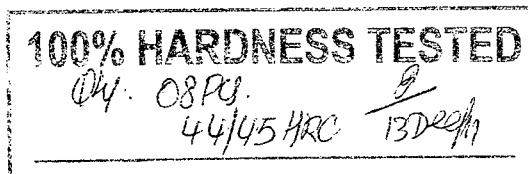
350-748 241/-141 CROSS TUBE EA 8 8

Process Specifications: Procedure: 4353
HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E
100% HARDNESS CHECKED AS PER ASTM E-18 40-45 HRC
MATERIAL: 4130

P/N D350-748-241
B73376, B73378, B73379, B73377
4 PCS

P/N D350-748-141
B74587, B74585, B74586, B74584
4 PCS

GRIT BLASTED



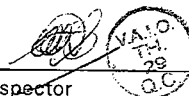
hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant hereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS